



Dart Aerospace Ltd.
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RBE117-12020W16
Job Sheet 192240



Part No: RBE117-12020W16

Job Qty: 1 pcs

Part Name: Base Extractor Free Wheel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 5/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 14456*

Note: DWG RBE117-12020W16 Rev.0 IPP Rev. A 19.03.13 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
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Container No: S194761



Part: RBE117-12020W16

Job No: 192240

Serial No/Batch: S194761

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 06/28/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	5/15/19		0.00	0.20	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	5/15/19		0.00	0.00	QC 5 - 10		JH
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	5/15/19		0.00	0.00	Packaging 3 - 1 - B4B		JH
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	5/15/19		0.00	0.00	QC 21 - FG - 21		JUN 28 2019 JH
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op
Descriptions: 100 - Assemble as per DWG.

FG Dock

DAS
70
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6630T22	Handle, Ø 32mm X M8 X 1.25, Black	2 (2 ea)	100-Small Fab - 1	5168184
90685A045	Hex Nut, M8 X 1.25	2 (2 ea)	100-Small Fab - 1	5168188
93275A034	Rod	1 (1 ea)	100-Small Fab - 1	5168182
93600A419	Dowel Pin, Ø 4mm X 8mm	3 (3 ea)	100-Small Fab - 1	5168186
97414A620	Retaining Ring	1 (1 ea)	100-Small Fab - 1	5168185
RBE117-12020W16-1	Frame	1 pcs (1 ea)	100-Small Fab - 1	5184306
RBE117-12020W16-3	Extractor	1 pcs (1 ea)	100-Small Fab - 1	5172684
RBE117-12020W16-5	Screw, Ø13/16 X 3-1/4	1 pcs (1 ea)	100-Small Fab - 1	5182376

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	6630T22	2	0	0
	90685A045	2	0	0
	93275A034	1	0	0
	93600A419	3	0	0
	97414A620	1	0	0
	RBE117-12020W16-1	1	0	0
	RBE117-12020W16-3	1	0	0
	RBE117-12020W16-5	1	0	0

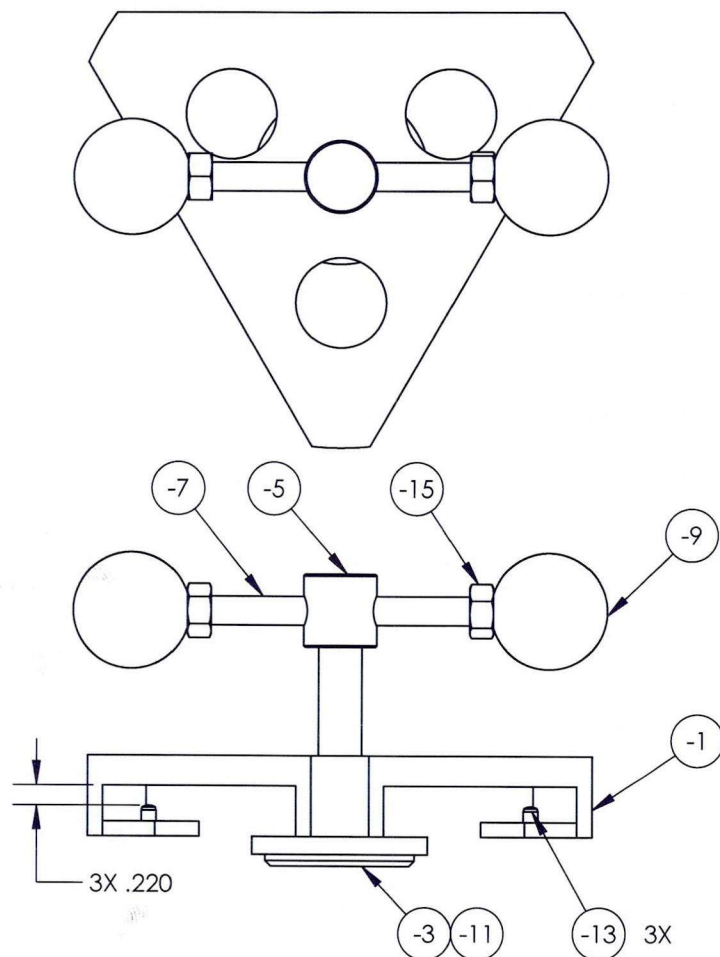
Part Specifications

Specifications could not be found.

Plex 3/20/19 7:46 AM Dart.lajeunesse.marie

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192240 W5
190320

NOTE:
REF. EUROCOPTER T/N 117-12020W16.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	FRAME	4140	Ø6 X 1	2
			-3	1	EXTRACTOR	1018	Ø2 X 1/2	3
			-5	1	SCREW	4140 Q&T	Ø13/16 X 3-1/4	4
		B/O	-7	1	ROD	C1541	Ø8mm X 110mm MCMaster-CARR #93275A034	1
		B/O	-9	2	HANDLE	POLYPROPYLENE	Ø32mm X M8 X1.25, BLACK MCMaster-CARR #6630T22	1
		B/O	-11	1	RETAINING RING	STEEL	Ø.165 X .02 GROOVE MCMaster-CARR #97414A620	1
		B/O	-13	3	DOWEL PIN	STEEL	Ø4mm X 8mm	1
		B/O	-15	2	HEX NUT	STEEL	M8 X 1.25 MCMaster-CARR #90685A045	1

 RED BARN MACHINE	
TITLE BASE EXTRACTOR FREE WHEEL	
DWG NO. RBE117-12020W16	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:1	DATE 3/12/2013
SHEET 1 OF 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					